

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028946**Date Inspected:** 05-Jan-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Fred Michels**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS Tower and OBG**Summary of Items Observed:**

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

At Tower elevation 157.789meter, ABF welder Ric Chouinard was observed continuing to perform all around 8mm fillet welding on one (1) 570mm long x 300mm wide x 25mm thick sole plate at South shaft skin plate 'D'. The welder was noted using Shielded Metal Arc Welding (SMAW) with 3.2mm E7018H4R electrode implementing ABF-WPS-D1.5-F1200A. The sole plate being welded is the bracket assembly for pipe supports for the domestic water and compressed air lines per CCO 203. Prior welding, the plates were preheated using propylene gas torch. ABF QC Fred Michels was noted on site monitoring the welders Ric Chouinard and Cris Bruce who was seal welding the top corners of tower shafts south and east.

At the request of Quality Control Field Supervisor, Bonifacio Daquinag, QA has randomly verified the QC VT/MT on various welded joints mentioned below. The QA verification was performed to verify that the welding and the VT/MT inspection performed by the QC inspector meet the requirements of the contract documents. At the conclusion of the QA verification it appeared that the welds and the QC inspection complied with the contract documents.

1. 13E-PP123-E2.8 BF3 – Skewed CJP welded T- joint cover QA verified.
2. 13E-EK-WP1 – K plate butt joint cover QA verified.
3. 12E-E2.1-C1 – drop-in side plate weld repairs at Y=0, Y=3900 and Y=12180mm.

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## WELDING INSPECTION REPORT

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At Tower elevation 157meter, ABF welder Ric Chouinard was noted continuing to perform all around fillet welding on the 570mm x 300mm x 25mm sole plate to tower head chimney south shaft skin plate 'D'.



At Tower elevation 157meter, ABF welder Ric Chouinard was observed continuing to perform all around fillet welding on the 570mm x 300mm x 25mm sole plate to south shaft skin plate 'D'.



### Summary of Conversations:

No significant conversation occurred today.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Lizardo, Joselito
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Reyes, Danny
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QA Reviewer
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